

Work Order ID 77179

77179

Page 1

November-28-11 9:02:55 AM

Item ID: D3499-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cable Guard Assembly
 Start Date: 28/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3499	Rev C								
100	*100* Small Fab	0.00	SP	12-01-17					
	Memo Assemble as per Dwg D3499	0.00	SP	12-01-17					
110	*110* QC	0.00							
	Quality Control	0.00							
120	*120* Packaging	0.00							
	Packaging	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 77179***77179***

Page 2

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Item ID: D3499-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cable Guard Assembly

Start Date: 28/11/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 2.00

2

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/1/23 ME
12-01-20

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NOTE: Date & initial all entries

Picklist Print

November-28-11 9:02:59 AM

Page 1

Work Order ID: 77179

77179

Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 06-05-05 JLM

IPP Rev:B As per Rev B 06-08-31 JLM

DD 10.02.23 verified by:EC

IPP Rev:C as per dwg revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C5A

Purchased

No

100

Each

1,297.000

2

4

AN3C5A

**

Bolt

Location

Loc Qty

Loc Code

FP

7

115835

7

ST350

1290

116419

28

117343

17

117764

52

117872

2

118451

191

119127

500

119749

500

12-01-17

12-01-17

14x

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Work Order ID: 77179

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Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C6A Purchased No

100 Each 344.0000 3 6

AN3C6A

BOLT

**

~~111982~~
SP

Location

Loc Qty

Loc Code

FP

1

111982

1

ST350

100

119449

100

ST351

243

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

88

119749

100

Lex.

AN960C10L NAS1149C0332 Purchased No

100 Each 0.0000 10 20

*AN960C10L *

washer

**

m119736.SP

D3499-2 Manufactured No

100 Each 8.0000 1 2

D3499-2

Mounting Plate

**

SP

Location

Loc Qty

Loc Code

ST207

8

44903

8

100 Each 0.0000 1 2

D3499-3 Manufactured No

D3499-3

Plastic Cable Guard

**

B446381X

1X

SP 12-01-17

B75365

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Work Order ID: 77179

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Parent Item: D3499-042

D3499-042

Parent Item Name: Cable Guard Assembly

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3499-5 Manufactured No

100 Each 19.0000 2 4

D3499-5

Placard

**

SP

Location

Loc Qty

Loc Code

ST062

19

46759

19

AN

D3672-1 Manufactured No

100 Each 1,188.0000 5 10

D3672-1

Phenolic Washer

**

SP

Location

Loc Qty

Loc Code

FP

424

66821

424

10R

ST074

764

72229

264

76277

500

MS21043-3 Purchased No

100 Each 954.0000 5 10

MS21043-3

Nut

**

SP 12-01-17

M119901

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

882

118077

1

118614

464

118686

167

119758

250

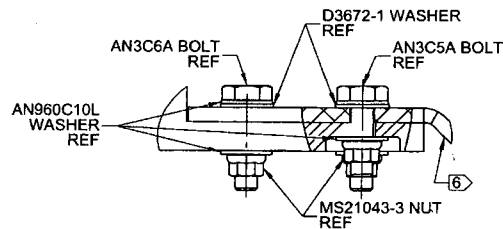
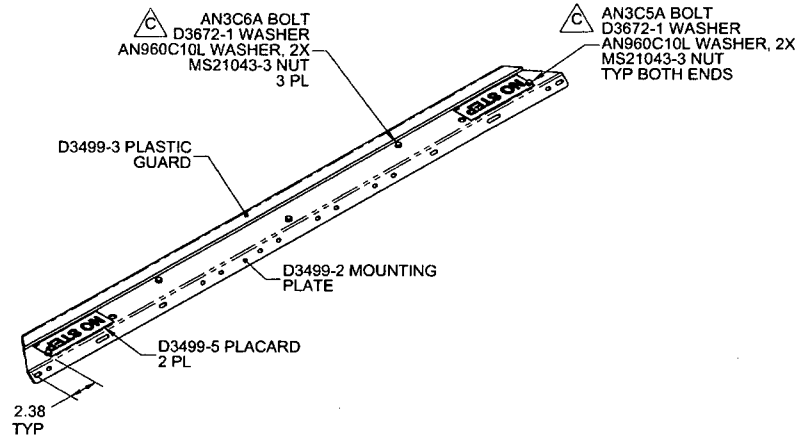
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

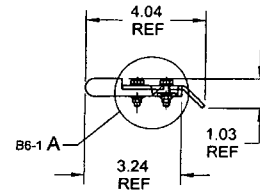
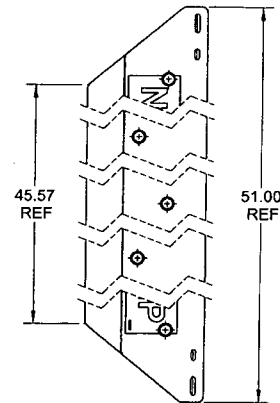
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DETAIL A
SCALE 4X



D3499-042 CABLE GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.90 lbs

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D3499-042	CABLE GUARD ASSEMBLY
2	1	D3499-2	MOUNTING PLATE
3	1	D3499-3	PLASTIC GUARD
4	2	D3499-5	PLACARD
5	2	AN3C5A	BOLT
6	3	AN3C6A	BOLT
7	10	AN960C10L	WASHER
8	5	MS21043-3	NUT
9	5	D3672-1	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77179

RELEASED
2010-02-02
MD

C	DRAWING UPDATED TO CURRENT STANDARDS. 3.245 WAS 3.225 (ZN B8-3); 3.24 WAS 3.25 (ZN D3-3); REVISE TOLERANCE & 2.01 WAS 2.00 (ZN D3-3); D3672-1 WAS NAS1515H-3L (ZN D3-1, D5-1, D7-1); ADD IDENTIFY NOTE (ZN A8-1); REF NCR-09-045	RF	09.06.19
B	RE-DESIGN D3499-2F/-3	MB	06.08.15
A	NEW ISSUE	MB	06.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RF</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>RF</i>		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>	DRAWING NO. D3499 REV. C SHEET 1 OF 4 TITLE CABLE GUARD SCALE NTS	
DATE	09.06.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

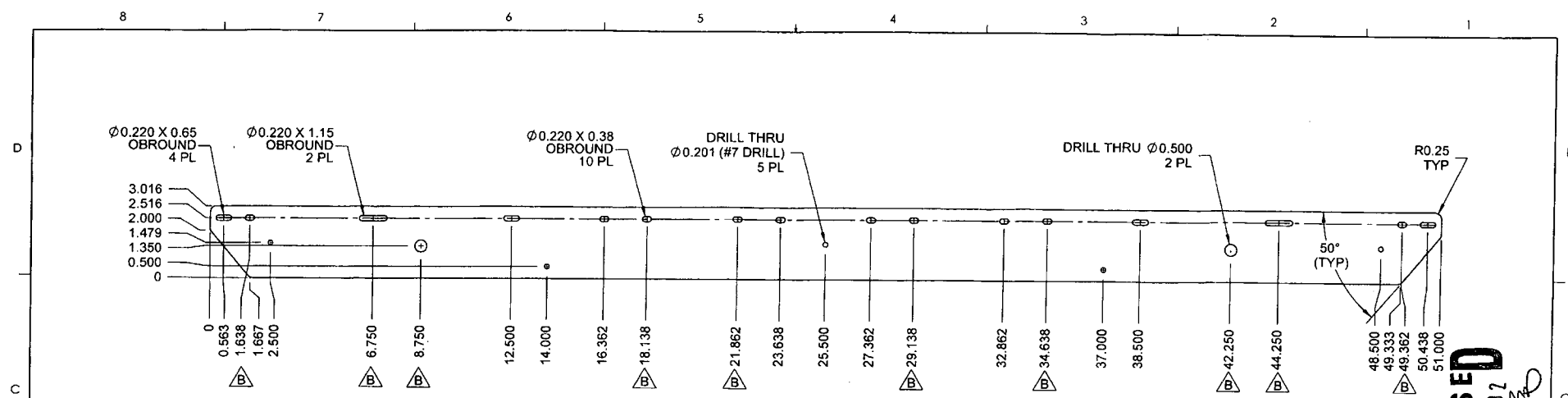
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

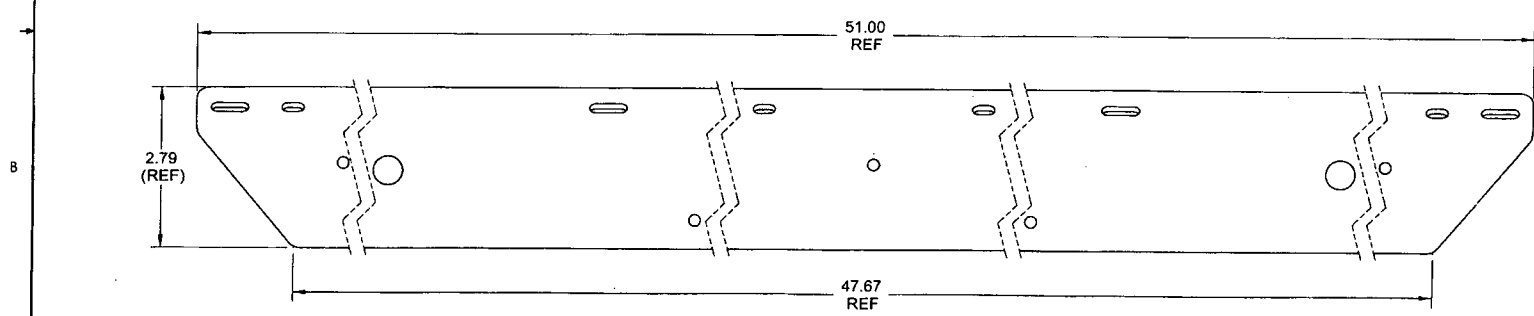
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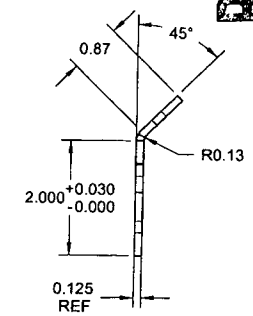
77179



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 0.5X



D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF. DART SPEC. M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.81 lbs

DESIGN	B	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	Y	DRAWING NO.	REV. C
MFG. APPR.		D3499	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CABLE GUARD	NTS
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R 2010-02-02 MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

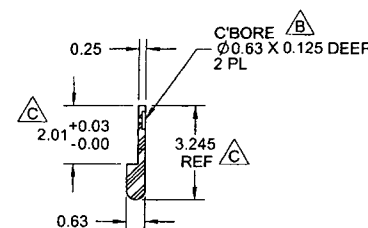
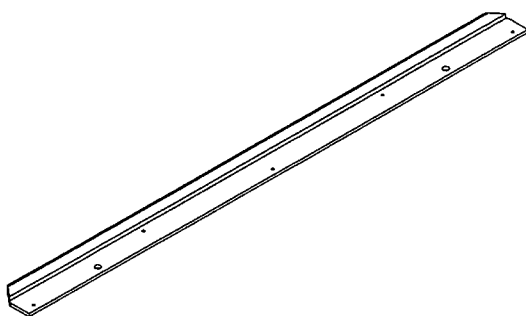
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

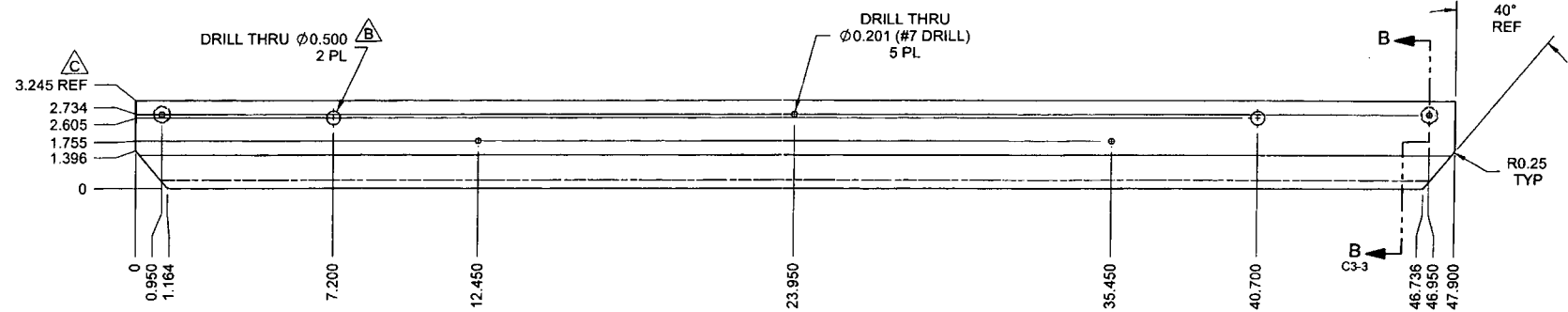
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77179



SECTION B-B B2-3



D3499-3 CABLE GUARD

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. MUHMB
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.52 lbs

DESIGN	13	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.		D3499	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CABLE GUARD	NTS
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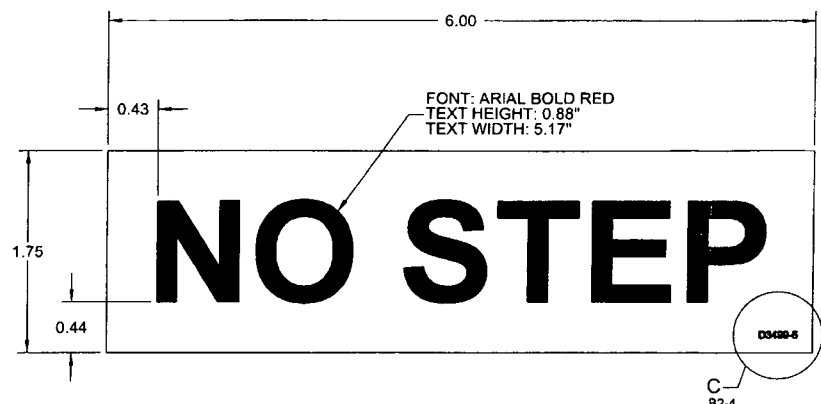
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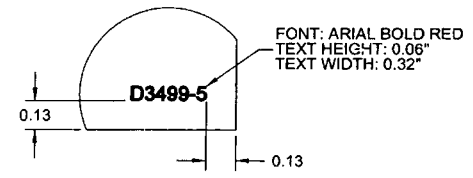
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D3499-5 PLACARD



DETAIL C B5-4
SCALE 2X

- NOTES:**
- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

RELEASED
2010-02-03

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3499	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CABLE GUARD	NTS
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